

KOBELCO

FAMILIARC™

MX-A70C6LF

Highly efficient metal-cored wire for carbon steel



High deposition rate with excellent weldability is created by a wide spray-transfer range

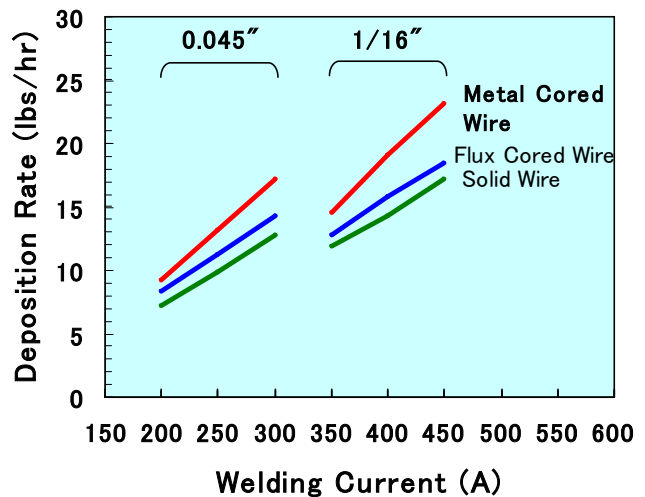
Code Data

AWS/ASME A5.18 E70C-6M

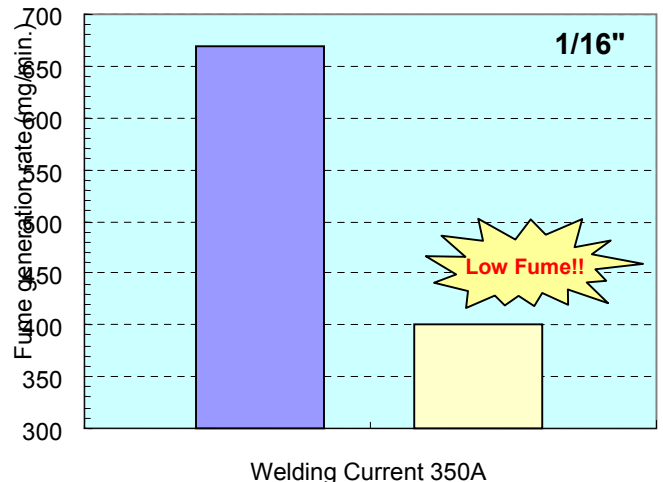
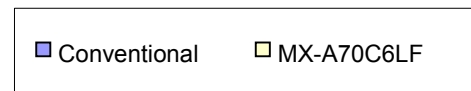
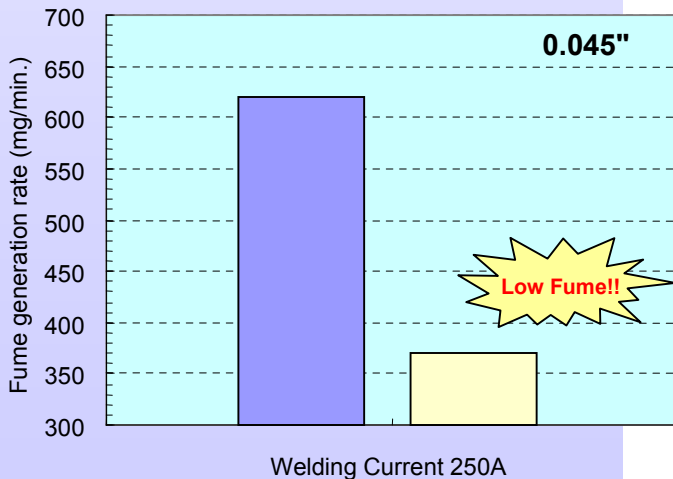
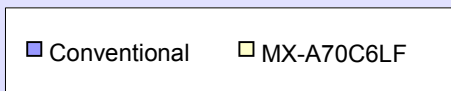
CWB W48-06 E492C-6M-H4

Outstanding Features

- MX-A70C6LF has lower fume and spatter generation than conventional metal cored wire.
- Its cored metal powder has higher deposition rates than solid wire or even flux cored wire.



Typical deposition rate of welding consumables



Fume generation (90%Ar-10%CO₂)

Typical chemistry of weld metal and diffusible hydrogen content (Wire size 1/16")

| Shielding gas | C | Si | Mn | P | S | Diffusible hydrogen content (ml/100g) |
|--------------------------|------|------|------|-------|-------|---------------------------------------|
| 80%Ar-20%CO ₂ | 0.04 | 0.79 | 1.62 | 0.008 | 0.009 | 2.9 |
| 95%Ar-5%CO ₂ | 0.04 | 0.85 | 1.69 | 0.007 | 0.010 | 3.5 |

Gas chromatography method (AWS A4.3)

Typical mechanical property of weld metal (Wire size 1/16" 340A)

| Shielding gas | 0.2%P.S (psi) | T.S (psi) | Elongation (%) | Impact value (ft-lbs) | |
|--------------------------|---------------|-----------|----------------|-----------------------|--------|
| | | | | -50 °F | -20 °F |
| 80%Ar-20%CO ₂ | 64,700 | 80,400 | 34 | 58* | 96 |
| 95%Ar-5%CO ₂ | 66,600 | 81,900 | 34 | - | 101 |

* Wire size 0.045" 280A

Recommended welding condition

| Wire size (in.) | Wire feeding speed (in./min) | Current (A) | Voltage (V) | Deposition rate (lbs/hr) | Wire stick out (in.) |
|-----------------|------------------------------|-------------|-------------|--------------------------|----------------------|
| 0.045 | 300 | 200 | 28-31 | 7.5 | 5/8"-3/4" |
| | 375 | 240 | 29-33 | 9.5 | |
| | 435 | 280 | 30-34 | 11.0 | |
| | 530 | 320 | 32-36 | 13.5 | |
| | 620 | 360 | 33-37 | 15.5 | |
| 0.052 | 250 | 230 | 27-29 | 8.5 | 3/4" -1" |
| | 300 | 270 | 28-32 | 10.5 | |
| | 400 | 320 | 30-34 | 14.0 | |
| | 460 | 370 | 31-36 | 16.0 | |
| | 545 | 420 | 32-37 | 19.0 | |
| 1/16 | 165 | 260 | 27-29 | 7.5 | 3/4" -1" |
| | 245 | 320 | 28-33 | 11.5 | |
| | 350 | 380 | 29-35 | 17.0 | |
| | 415 | 440 | 30-36 | 20.0 | |
| | 490 | 500 | 31-37 | 24.0 | |